

# Work Order ID 63637

Friday, November 05, 2010 2:42:56 PM



Page 1

Item ID: D206-667-203TRN

Accept



Setup Start



Revision ID:

Item Name: Crosstube Turning Detail

Stop



Start Date: 11/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/15/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

10-11-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-667-243	Rev C

100	MORI SEIKI CNC LATHE LARGE	0.00							
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089□2-Turn first side as per Folio FA089□3-File down transition lines smooth.								

*amb 10/11/10*

110	QC1- Inspect dimensions to dimension sheet	0.00							
QC	Memo	0.00							
Quality Control									

*amb 10/11/10*

120	MORI SEIKI CNC LATHE LARGE	0.00							
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA089□2-File down transition lines smooth. □ 3-Remove sand and plugs□4-Scrib part# and batch #								

*amb 10/11/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC1 - Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

ant 10/11/10

Quality Control

\_\_\_\_\_

140

QC8 - Inspect parts - second check

0.00



QC

Memo

0.00

S 10/11/12

Quality Control

\_\_\_\_\_

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

SAD  
10-11-12

Hand Finishing Crosstubes

\_\_\_\_\_

W/O:		WORK ORDER CHANGES					
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Page 3

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Start Date: 11/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/10/11/12

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and Stock in kanban rack Location: LG SAD 10-11-12

①

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/15

10-11-12

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, November 05, 2010 2:43:00 PM

Page 1

Work Order ID: 63637



Parent Item: D206-667-203TRN



Parent Item Name: Crosstube Turning Detail

Start Date: 11/5/2010

Required Date: 11/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec  
 IPP Rev B 08.04.02 Removed polish EC verified by: DD  
 IPP Rev C 09.01.06 ECN 08-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6004-115 		Manufactured	No			100	Each	50.0000	1	1			

Crosstube Material

Location	Loc Qty	Loc Code
LG	50	
34685	17	
34774	2	
→ 38336	31	

1 *ank* 10/12/10

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 68637
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b> D206-667-243
<b>Inspection Dwg:</b> D206-667-243 Rev: C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.495	✓	Vern	ML-7
	2.018	+0.005/-0.000	2.023	✓	"	"
	2.079	+0.005/-0.000	2.084	✓	"	"
	2.145	+0.005/-0.000	2.150	✓	"	"
	2.209	+0.005/-0.000	2.214	✓	"	"
	2.287	+0.005/-0.000	2.292	✓	"	"
	2.363	+0.005/-0.000	2.364	✓	"	"
	2.433	+0.005/-0.000	2.438	✓	"	"
	0.200	+/-0.010	.200	✓	"	"
	0.500 x 30°	+/-0.010	.500x30°	✓	"	"
	R0.063	+/-0.010	R-0.063	✓	Rad gage	REF
	R0.500	+/-0.010	R-.500	✓	"	"
	4.438	+/-0.030	4.438	✓	Vern	ML-7
SIDE B	104.91	+/-0.020	104.915	✓	M-tape	ML-5
	2.490	+0.005/-0.000	2.495	✓	Vern	ML-7
	2.018	+0.005/-0.000	2.023	✓	"	"
	2.079	+0.005/-0.000	2.084	✓	"	"
	2.145	+0.005/-0.000	2.150	✓	"	"
	2.209	+0.005/-0.000	2.214	✓	"	"
	2.287	+0.005/-0.000	2.292	✓	"	"
	2.363	+0.005/-0.000	2.364	✓	"	"
	2.433	+0.005/-0.000	2.438	✓	"	"
	0.200	+/-0.010	.200	✓	"	"
	0.500 x 30°	+/-0.010	.500x30°	✓	"	"
	R0.063	+/-0.010	R-0.063	✓	Rad gage	REF
	R0.500	+/-0.010	R-.500	✓	"	"
	4.438	+/-0.030	4.438	✓	Vern	ML-7

<b>Measured by:</b> <i>aml</i>	<b>Audited by:</b> <i>G</i>	<b>Preliminary Approval:</b>	N/A
<b>Date:</b> 10/11/10	<b>Date:</b> 10/14/12	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	
B	10.08.25	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER  
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE  
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE  
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43637  
*B/10-12-08*

RELEASED  
*08/11/12*

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>RF</i>	<b>DART AEROSPACE LTD</b> HAWKESSBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. REV. C D206-667-243 SHEET 1 OF 4	
CHECKED	<i>RF</i>	TITLE SCALE CROSSTUBE ASSY (206L HIGH AFT) NTS	
MFG. APPR.	<i>RF</i>	DATE 08.11.06	
APPROVED	<i>RF</i>	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	<i>RF</i>		

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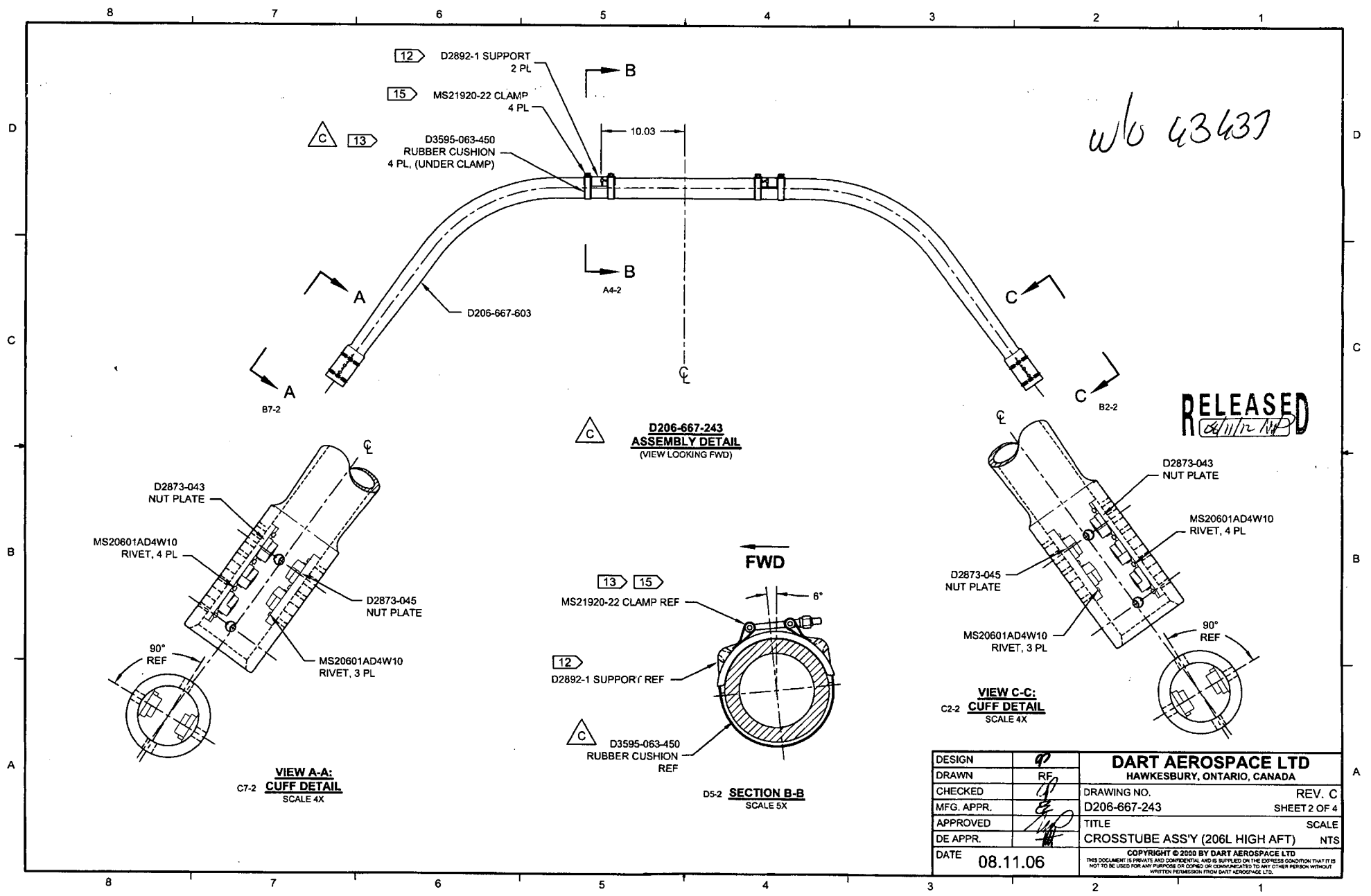
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

W/L 43437

RELEASED  
28/11/12



VIEW A-A:  
C7-2 CUFF DETAIL  
SCALE 4X

SECTION B-B  
D5-2  
SCALE 5X

VIEW C-C:  
C2-2 CUFF DETAIL  
SCALE 4X

DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. C
MFG. APPR.	97	D206-667-243	SHEET 2 OF 4
APPROVED	97	TITLE	SCALE
DE APPR.	97	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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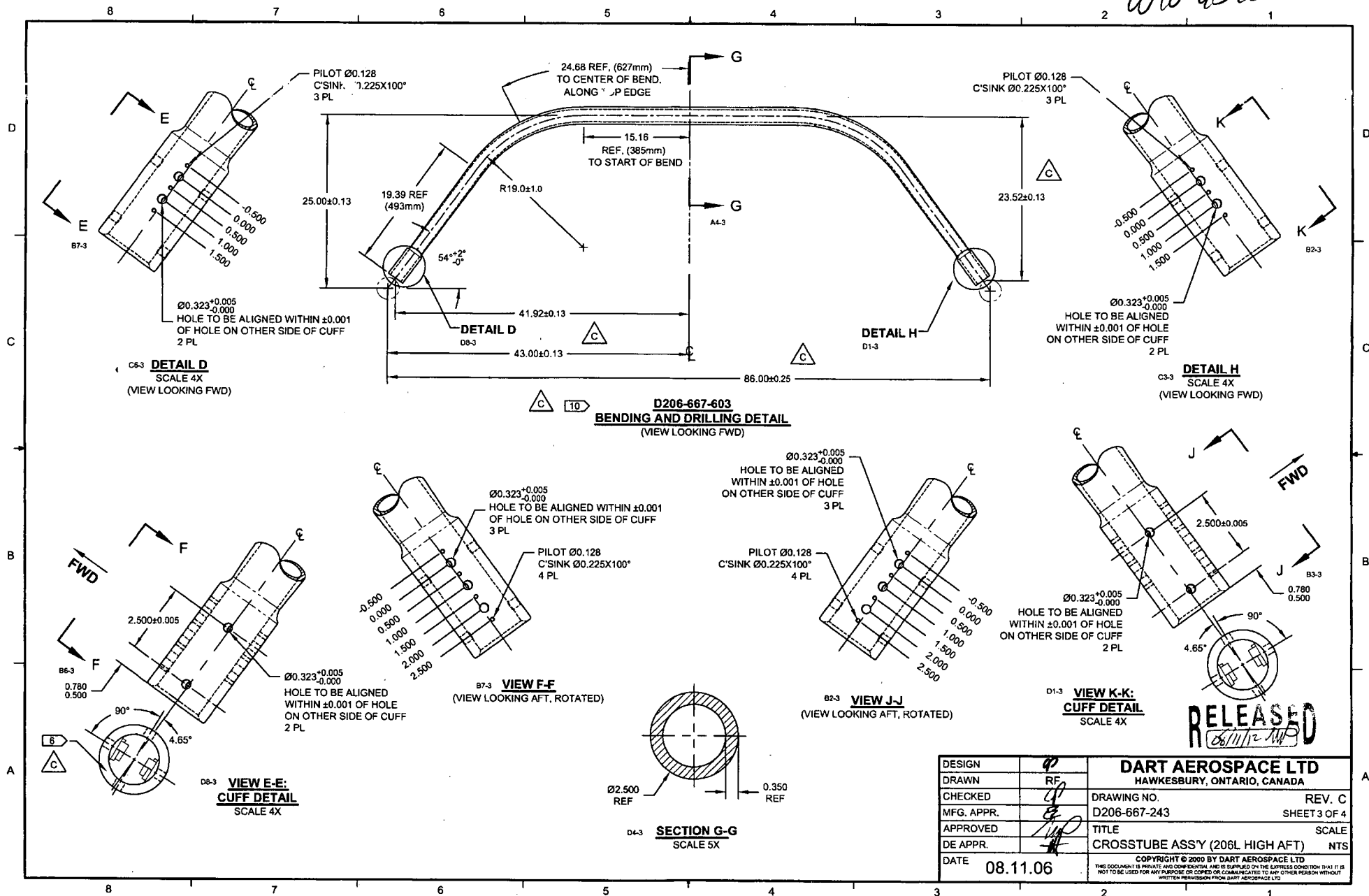
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O 43437



DESIGN	Q	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. C
MFG. APPR.	Q	D206-667-243	SHEET 3 OF 4
APPROVED	Q	TITLE	SCALE
DE APPR.	Q	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
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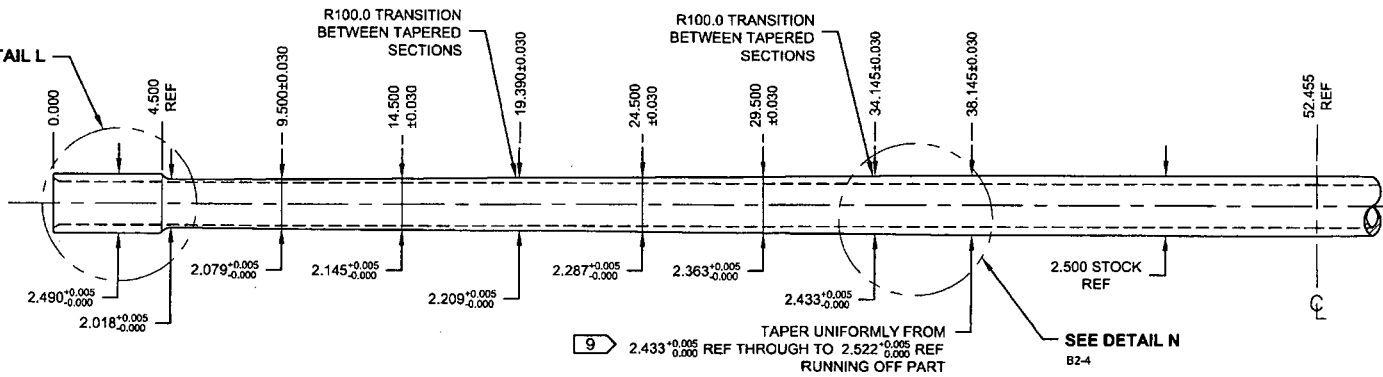
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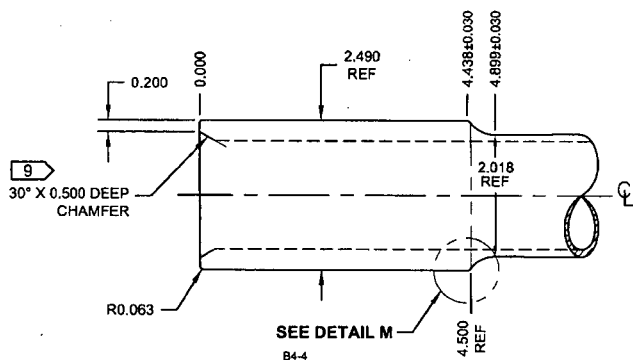


u/b 63637

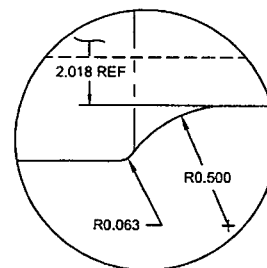
SEE DETAIL L  
B7-4



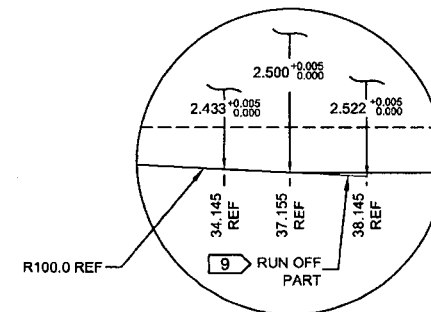
**TURNING DETAIL**



**DETAIL L: CROSSTUBE CUFF**  
NOT TO SCALE



**DETAIL M: CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

**RELEASED**  
08/11/06

DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LP	DRAWING NO.	REV. C
MFG. APPR.	EP	D206-667-243	SHEET 4 OF 4
APPROVED	SP	TITLE	SCALE
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